

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BRACKET		
Job Number	: 37170				
Estimate Number	: 11147				
P.O. Number	:	Part Number	: D3209041		
This Issue	: 2/4/2008 S.O. No. :	Drawing Number	: D3209 REV A		
Prsht Rev.	: NC	Project Number	: N/A		
First Issue	: / / Type : MACHINED PARTS	Drawing Revision	: A		
Previous Run	: 30832	Material	:		
Written By	: <u>JF 08 02 at</u>	Due Date	: 2/15/2008	Qty:	4 Um: Each
Checked & Approved By	: _____				
Comment	: Est A 04.06.09 New issue KJ/RF				

Job Number:

1.0	M6061T6B1500X01250	6061-T6 Bar 1.5" x 1.25"
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Comment: Qty.: 0.1838 f(s)/Unit Total: 0.7350 f(s)
Material: 6061-T6 (QQ-A-200/8 or QQ-A-250/11 or QQ-A-225/8)
(M6061T6B1.500x01.250)
Identify for D3209-1
Batch: 1104183

2.0	BAND SAW	BAND SAW
-----	----------	----------

Comment: BAND SAW
Cut blanks: 1.500" x 1.250" x 1.950" long Bar (+0.030/-0.000)

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
Machine D3209-1 as per Folio FA345 and Dwg D3209
Identify as D3209-1
Deburr and Tumble

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0 QC8 " SECOND CHECK

Comment: SECOND CHECK

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ED Date: 08/02/08
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 2/4/2008 11:25:42 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 37170

Part Number: D3209041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



(4X)

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M. H.

08/02/06

7.0

POWDER COATING

POWDER COATING



M 106442

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

Note: Cover the hole for D3209-1 before powder coat.

F2 08/02/07 (4)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(4X)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M. H.

08/02/07

9.0

D32093

Bushing



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bushing

Pick:

Qty Part Number Description Batch

1 D3209-3 Bushing

29907

Press fit bushing into the bracket as per Dwg D3209

AS 08/02/07 (4)

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/02/07 (4)

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST77

AS 08/02/07 (4)

12.0

QC21

FINAL INSPECTION/W/O RELEASE



(4)

Comment: FINAL INSPECTION/W/O RELEASE

08/02/08

Job Completion



u 08.02.08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

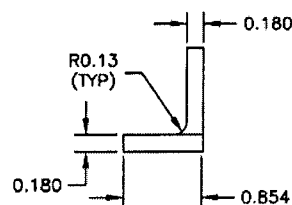
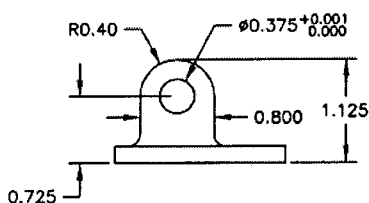
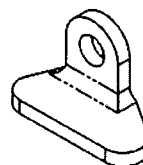
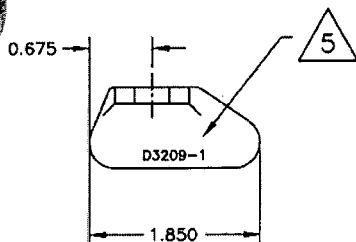
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



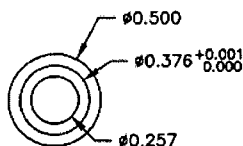
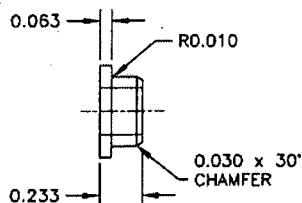
DESIGN FF	DRAWN BY FF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3209	REV. A SHEET 1 OF 1
DATE 04.01.27		TITLE BRACKET	SCALE 1:2
A	04.01.27	NEW ISSUE	

RELEASED
04.04.05



2

D3209-1 BRACKET



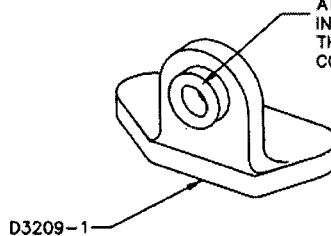
3

**D3209-3 BUSHING
SCALE 1:2**

4

D3209-041 ASSEMBLY

D3209-3 BUSHING
PRESS FIT, HEAD
AT THIS FACE
INSTALL AFTER
THE CONVERSION
COAT



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER
NO. 37170

D3209-1 BRACKET: D3209-3 BUSHING

- 1) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 2) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8)
ALUMINUM BAR (M6061T6B)
- 3) MATERIAL: AISI 303 SS (M303R)
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 5) ENGRAVE DART P/N AS SHOWN
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE INCHES

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